

GOLD 310-E

FOR STAINLESS STEELS

Description and Applications:

Highly alloyed , easy to weld **stainless steel maintenance electrode**.Cr-Ni-Mo with very low carbon , **for welding 304, 304L, 347,316L, 318 stainless steels** at service temperatures of -120°C to 350°C .

Used in food-, brewing-, pharmaceutical -, chemical -, petro-chemical - industries, in water treatment, for tanks, pumps, mixers turbine blades etc.

For joining and overlaying of food processing and dairy equipment, pipes tanks etc.

-No spatter, no overheating, high acid and corrosion resistance

-Fully austenitic deposit

-Probably the finest stainless steel electrode available

-Can be welded at low amperages reducing heat damage



Mechanical properties

R_m (MPa)	R_{p0,2} (MPa)	A₅ (%)
580	420	40

Up to:

Packaging
Data

Sizes	2.5x300	3.2x350	4.0x450
Kgs/ Packet	4	4,5	5,5
Packets/ carton	4	4	4
Kgs/ carton	16	18	22

HINTS:

Current (A) DC+,AC OCV 70	70	100	130
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Welding positions



Recommendations for stainless steel welding:

Clean weld area. Bevel heavy sections 60° - 90° Vee

Select lowest possible amperage

Weld with stringer beads and use short arc. Remove slag between passes

Use only stainless steel brushes to clean welds

Use staggered weld sequence to balance heat input. For maximum corrosion resistance remove discoloration by brushing or pickling